

Work Order ID 102657-2

June-06-13 8:31:47 AM

Item ID: D4798-041

Revision ID:

Item Name: Wearplate Assembly

Start Date: 6/06/13 Start Qty: 4.00

Required Date: 6/10/13 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan: MLJ

QC:

Date: 13-06-06 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr Revision Nbr

D4798 B

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut D4798-1 as per Dwg

Dwg Rev: B

Prog Rev: B

304.063

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

REVB

D4798-041

B102657

Page 1

split 2

102657

4 3

4

8 0 JMB-6-7

8 0 JMB-6-7

Work Order ID 102657

June-06-13 8:31:47 AM

102657

Page 2

Item ID: D4798-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Assembly

Start Date: 6/06/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/10/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approval:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
21
13.67

8

130

0.00

130

Large Fab

Memo

0.00

Large Fab

USE DT9891 WELDING FIXTURE

1- Weld cups as per dwg

A/R S.S. ROD BATCH: M/22357

2- Apply hardfacing on wearplate as indicated on dwg

A/R HARDCOAT 2059B BATCH: M/25337 → 20596

③ me 13-07-04

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

③ 13-07-04

DAS
09
2-89



Work Order ID 102657

Thursday, July 04, 2013 12:40:46 PM

102657

Page 3

Item ID: D4798-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Wearplate Assembly

Stop *NS2*

Start Date: 6/6/2013 Start Qty: 8.00

8

Cust Item ID:

Required Date: 6/10/2013 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

QC

Memo

0.00

Quality Control

③ 13-07-04

DAS
09

160

Identify as per dwg & Stock Location: ^{change} ST256

0.00

160

Packaging

Memo

0.00

Packaging

3

13-07-05 JB

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

13/7/8 JH

me
13-7-3

BQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

June-06-13 8:31:51 AM

Page 1

Work Order ID: 102657

Parent Item: D4798-041

Start Date: 6/06/13

Required Date: 6/10/13

Parent Item Name: Wearplate Assembly

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP REV:A NEW ISSUE 13-03-26 JLM VERIFIED BY:DD
DWG REV.B DD VERF:JLM

IPP REV:B 13.05.28 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4379-1
Wearplate Cup

Manufactured

No

Each 57.0000

③ 40 13-07-03

B 102978 x 30

Location

Loc Qty

Loc Code

WA001

57

87518

1

98840

25

99275

31

+25

M304S16GA

Purchased

No

sf

374.0602

48421053
76.0

Jm13-6-7

304/316 Sheet D63

Location

Loc Qty

Loc Code

MAT020

374.0601686

122245

0.1713688

123136

140.8

124428

23.61

124572

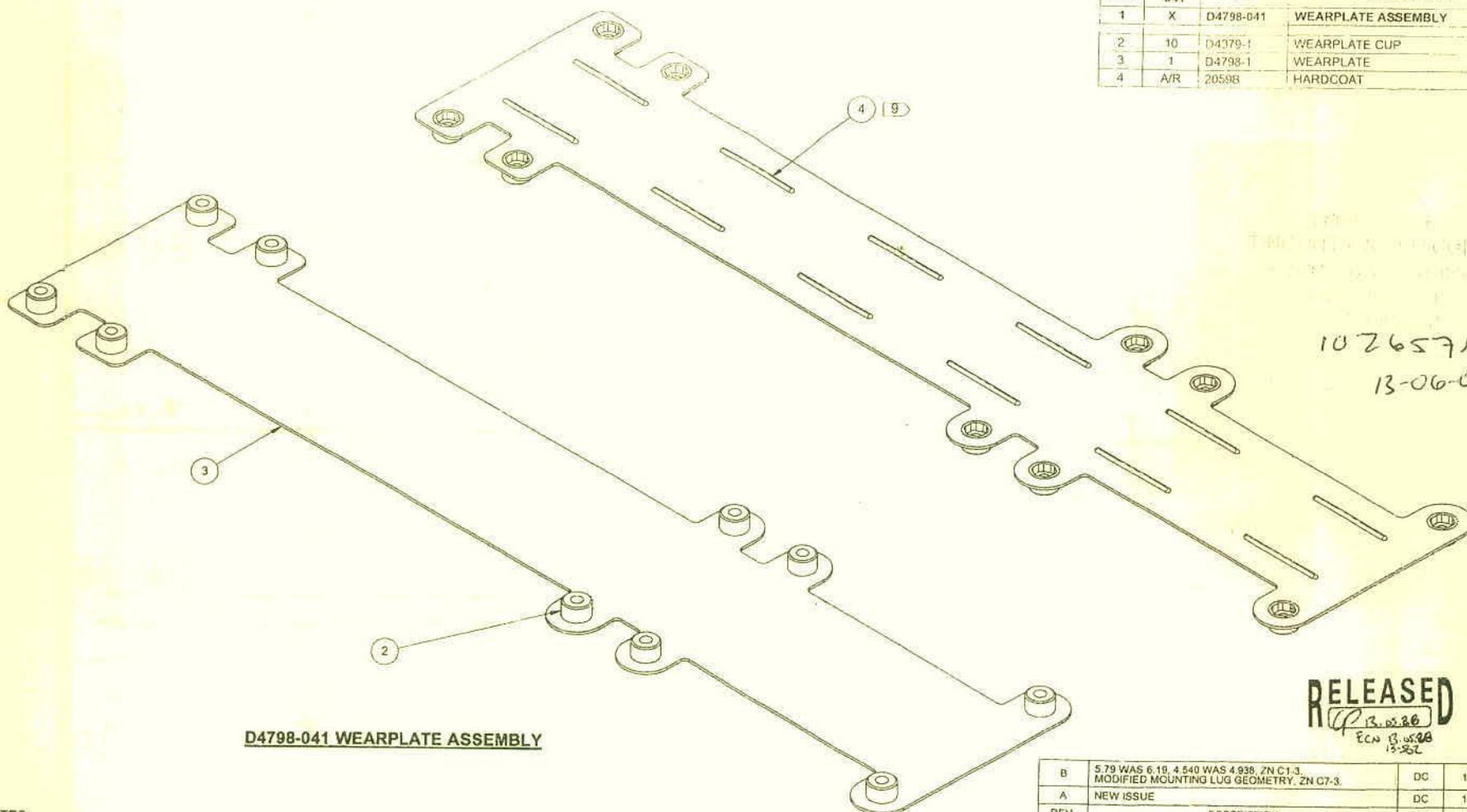
21.4181688

125599

188.060631

125599

ITEM	QTY	P/N	DESCRIPTION
1	X	D4798-041	WEARPLATE ASSEMBLY
2	10	D4379-1	WEARPLATE CUP
3	1	D4798-1	WEARPLATE
4	A/R	2059B	HARDCOAT



D4798-041 WEARPLATE ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 2.05 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 12 PL

RELEASED
 13.05.06
 ECN 13.05.06
 13.06

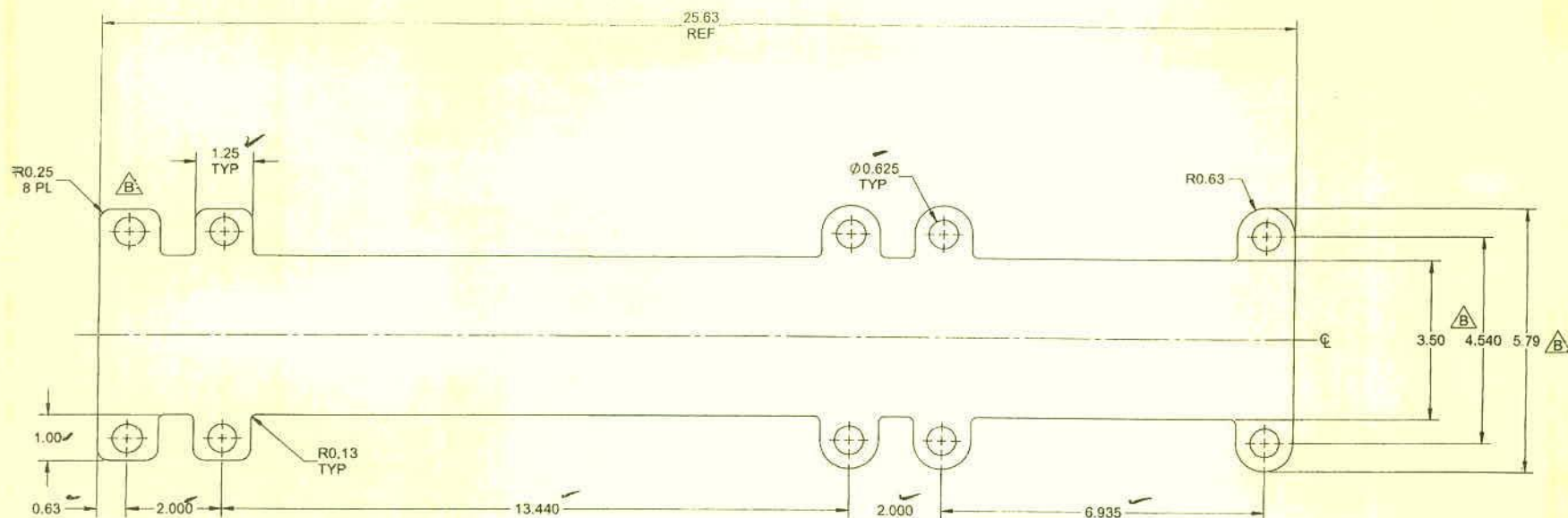
B	5.79 WAS 6.10, 4.540 WAS 4.938, 2N C1-3, MODIFIED MOUNTING LUG GEOMETRY, 2N C7-3.	DC	13.05.06
A	NEW ISSUE	DC	13.03.20
REV	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	DC		
CHECKED	DC		
MFG. APPR.	DC		
APPROVED	DC		
DE APPR.	DC		
DATE	13.05.06		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4798** REV. B
 SHEET 1 OF 3
 TITLE **WEARPLATE ASSEMBLY** SCALE NTS

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102657

**D4798-1 WEARPLATE****RELEASED****NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.82 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DF	DRAWING NO. D4798	REV. B
MFG. APPR	df		SHEET 3 OF 3
APPROVED	df	TITLE WEARPLATE ASSEMBLY	SCALE
DE APPR	df		NTS
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